

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005416**Date Inspected:** 24-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sha Zhi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG segments**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG outside assembly (OBG segment 3AW)

This QA observed ZPMC qualified welding personnel identified as Mr. Lu Xun Ping (067610) perform SMAW weld on weld joint identified as SSD11A-PP021-186, 179 and 180. ZPMC QC identified Mr. Li Yan Hua was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114-Tc-U5b-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Zang Wei (066413) perform SMAW weld on weld joint identified as SSD11A-PP021-183 and 184. ZPMC QC identified Mr. Li Yan Hua was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2233-Tc-U5b-F.

OBG outside assembly (OBG segment 3BW)

This QA observed ZPMC personnel cleaning the inside of this segment in preparation for blast and paint. No other work was observed on this segment while QA was present.

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OBG outside assembly (OBG segment 3AE, 3BE and 4AE)

This QA noted that ZPMC has moved three additional OBG segments identified as 3AE, 3BE and 4AE to the outside of the paint bay. No significant work was observed on segments 3BE and 4AE while QA was present.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Lin Jiang (051356) perform FCAW welding on weld joint identified as SSD16A-PP020-220 and 221. ZPMC QC identified Mr. Li Yan Hua was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U4c-F.

OBG assembly bay 19

This QA observed ZPMC personnel flame straightening tower base plates. ZPMC QC was observed by this QA monitoring the process. The procedure appeared to be in general compliance with AWS D1.5 2002 and the contractors WQCP section 11.

OBG outside assembly (OBG segment 4BW)

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Hua Jun (066258) perform SMAW weld on weld joint identified as SSD10A-PP026-173. ZPMC QC identified Mr. Zhang Xiao Ming was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Li Zai Jun (037996) perform SMAW weld on weld joint identified as SSD11A-PP027-170. ZPMC QC identified Mr. Zhang Xiao Ming was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Feng Jin Dou (0067572) perform SMAW weld on weld joint identified as SSD12A-PP028-171. ZPMC QC identified Mr. Zhang Xiao Ming was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

This QA observed ZPMC qualified welding personnel identified as Mr. Wang Chang Ming perform SMAW weld on weld joint identified as SSD12A-PP026-176. ZPMC QC identified Mr. Zhang Xiao Ming was present to monitor the weld repair process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM.

OBG outside assembly (OBG segment 5CW, 5BW, 5AW, 5CE and 4AW)

No significant work was observed on these segments while QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the

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applicable contract documents.



## Summary of Conversations:

only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hall,Steven	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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